Work Order Wednesday, March	ID 67123 09, 2011 8:20:43 AM										Page 1
Revision ID:	183-045 uring Assembly		Accept						Setup Sta Sto	1 (881)(8) 8	
Start Date: 3/9. Required Date: 3/1 Reference:	/2011 Start Qty: 20.0 1/2011 Req'd Qty: 20.0				Cust Item II Customer:	D:					
Approvals: Pr	rocess Plan:	Date: Date:	Tooli	ng:(Y/N):		nte:		I	Run Sta Sto		
Sequence ID/ Work Center ID	Operation Description			t Up/ in Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr										
D3183	Rev C1										
Hardinge CNC Lathe Sm	Hardinge CNC LATI Memo Turn D3		0.00 0.00 Folio FA388© Deburr)				20	\$		
110 QC Quality Control	QC2- Inspect parts o Memo	ff machine FAI/FA	AIB 0.00		[10			20	- J		-
120	QC8- Inspect parts -	second check	0.00							-	

Quality Control

Memo

0.00 ml 1103/10

Dart Aerospace Ltd

- uit 710	Oopaoc	Liu							
W/O:			V	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				·					
Part No	:	PAR #:	Fault Ca	tegory:	NCR: Ye	s No D	QA:	Date: _	
	R	esolution:	Disposit	ion:	_ QA: N/C	Closed: _		Date: _	
NCR:		·	WORK OR	DER NON-CONFORMA	NCE (NO	CR)			
DATE	STEP	Description of NC		Corrective Action Section		Ver	ification	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da		ection C	Chief Eng	QC Inspector
				,					

Work Order ID 67123

Wednesday, March 09, 2011 8:20:43 AM



Page 2

Item ID:

D3183-045

Accept

Setup Start



Stop

Stop

Revision ID: Item Name:

Bearing Assembly

Start Date: 3/9/2011

Start Qty: 20.00

Req'd Qty: 20.00 Required Date: 3/11/2011

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Date:

Tool # Plan

Accept Qty

Reject

Reject

Insp.

Work Center ID 130

Sequence ID/

Small Fab Small Fab

Small Fab

Operation

Description

Memo

0:00

0.00

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

Code

Qty

Number

Stamp

140

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

uloslu

150

Packaging

Packaging

Identify as per dwg & Stock Location: 236

0.00

Memo

Memo

0.00

Dart Ae	rospace	Ltd							•
W/O:			WO	RK ORDER CHANG	ES			· · · · · · · · · · · · · · · · · · ·	
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date: _	
	Re	solution:	Disposition	ı:	_ QA: N/C Clo	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
		Description of NC		Corrective Action Secti	on B	Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	I -	ion C	Chief Eng	QC Inspector
			7						

Work Order ID 67123

Page 3

Wednesday, March 09, 2011 8:20:43 AM

Item ID:

D3183-045

Revision ID:

Item Name:

Bearing Assembly

Start Date:

3/9/2011

Start Qty: 20.00

Required Date: 3/11/2011

Req'd Qty: 20.00



Accept

Setup Start

Stop



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Operation

Description

Date:_

QC21- Final Inspection - Work Order Release

Tooling: Date:

SPC (Y/N):

Set Up/

Date:

Tool ID

Date:

Start Run



Stop

Sequence ID/

Work Center ID

160

Memo

Run Hours

0.00

Tool # Plan

Accept Qty Code

Reject Qty

Reject Number

Insp. Stamp

Quality Control

0.00

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	RES		<u></u>			
DATE	STEP	PRO	OCEDURE CHA	NGE	E	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
·			***************************************				· · · · · · · · · · · · · · · · · · ·			
Part No	:	PAR #:	Fault Cate	gory:	NCR:	Yes N	lo DQ/	A :	Date: _	
	R	esolution:	Dispositio	n:	QA: N	/C Clo	sed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR)				
DATE	STEP	Description of NC			tion B	·! 9	Verific		Approval	Approval
————	OILI	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti	on C	Chief Eng	QC Inspector
								•		

Picklist Print

Wednesday, March 09, 2011 8:20:40 AM

Work Order ID: 67123

Parent Item:

D3183-045

Parent Item Name: Bearing Assembly



Start Date: 3/9/2011

Required Date: 3/11/2011

Page 1

Start Qty: 20.00

Required Qty: 20.00

C	4	
Com	ments:	

A□04.02.18□New issue□KJ/DS□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3183-5		Manufactured	No			110	Each	46.0000		20/	Sufo	3/10	
				Location		Loc (<u>Qty</u>	Loc Code			•	•	
		•		ST236			46		_		_		
		•			47606		1		_		_		
					52135		2		_		_	•	
					67065		43		_	20			
MDELRINR 1.000		Purchased	No			130	f	16.1250	0.0333	0.70105	3	103	112
				Location		Logi	Ω4	Los Codo					

Location Loc Oty Loc Code MAT 16.125 116266 16.125

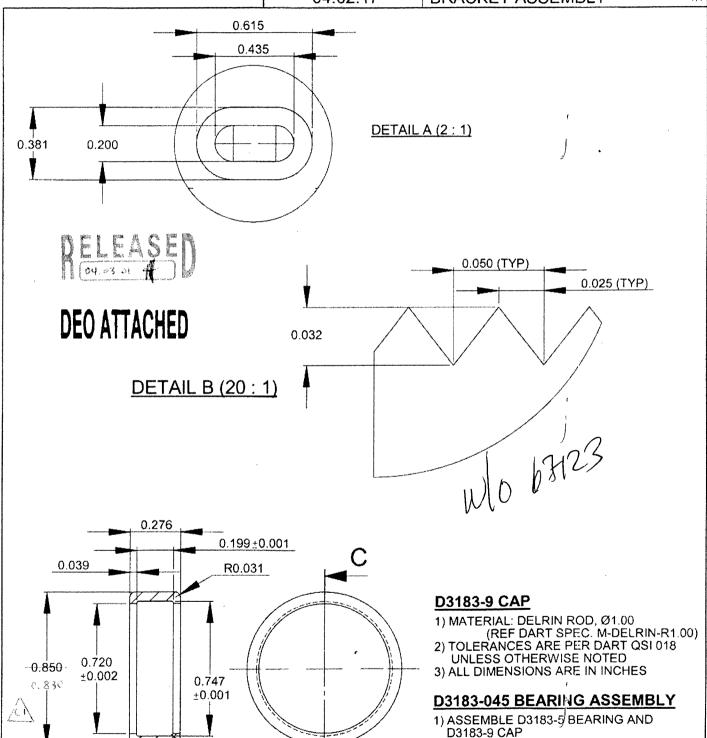
Dart Aerospace Ltd

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W/O:			W	ORK ORDER CHANGI	ES	· · · · · · · · · · · · · · · · · · ·			
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						-		F100 Wigi	
									j
						···			
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQA	۸:	Date: _	
	R	esolution:	Dispositi	on:	_ QA: N/C Clo	osed:		Date: _	
NCR:		1	WORK ORE	DER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
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DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECKED	APPROVED	D3183	REV. C SHEET 4 OF 4
DATE		TITLE	SCALE
04.	02.17	BRACKET ASSEMBLY	1:1



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R0.010

SECTION C-C SCALE 2:1

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W/O:			WORK ORDER C	HANGES				
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							,	1
Part No):	PAR #: _	Fault Category:	NCR: Ye	s No DQ	A:	Date: _	
	Re	solution:	Disposition:	QA: N/C	Closed:		Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)											
		Description of NC		Corrective Action Section B		Verification	Approval	Approval					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector					
								·					
							2	<u>.</u>					
					ļ !								

DART AEROSPACE LTD	Work Order: 6 4(2-5)	
Description: Cap	Part Number: D3183-9	
Inspection Dwg: D3183 Rev: C1	Page 1 of 1	

	FIRS	T ARTICLE IN	NSPECTI	ON CHE	ECKLIST		
		First Artic	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o		nments
Ø0.830	+/-0.005	830			llela	2/	
Ø0.720	+/-0.002	.721					}
Ø0.747	+/-0.001	1.748					
R0.010	+/-0.010	R.07				1	
R0.031	+/-0.010	52.025	/,				
0.199	+/-0.001	-192					
0.276	+/-0.010	-278					
0.039	+/-0.010	-040		·			
Measured by:	5	Audited by:	Qu,		Prototype	e Approval:	N/A N/A
Date: [1/3/10	Date:	11/03	10		Date:	
Rev Date A 04.04.20	Change New Issue	(P/O D3183	-045)			Revised by KJ/RF,	Approved

Rev	Date	Change	Revised by	Approved
Α	04.04.20	New Issue (P/O D3183-045)	KJ/RF,	1
В	06.03.09	Dimension Ø0.830 was Ø0.850	KJ/JLM X	ad
			70	727